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D4776-1**Job Sheet 193742****Part No:** D4776-1**Job Qty:** 2 pcs**Part Name:** Basket Strut Clevis**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/22/19**Job Tracking No:****Due Date:** 5/6/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG D4776 REV.E IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1 <i>pull from stock 2x D4776-1</i>	2 pcs		5/6/19	0.54	1.06	Doosan - <i>packaging 1-1</i>		
105	QC 2	2 pcs		5/6/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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111	QC 8	2 pcs	5/6/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
112	Handfinish - 1-1 Chemical- B4B	2 pcs	5/6/19	0.00 0.06	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 -	

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113	QC 7	2 pcs	5/6/19	0.00 0.00	B4B	
					QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
115	Powdercoat - 1 White Qt(A)- B4B	2 pcs	5/6/19	0.00 0.02	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
116	QC 3	2 pcs	5/6/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
130	Packaging 3-1 - Stock - B4B	2 pcs	5/6/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	

				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	2	5/6/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53

APR 30 2019

Part Op **100** - (Doosan Lathe) 1- Turn as per Folio FB167 Rev: _____ & Dwg D4776 Rev: _____ 2-Deburr per dwg D4776
 Descriptions: **105** - (QC2- Inspect parts off machine FAI/FAIB)
111 - (QC8- Inspect parts - second check)
112 - (Chemical Conversion Coat per QSI005 4.1)
113 - (QC7-Inspect Chemical Conversion Coat)
115 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) MASK .403 ROUND SECTION AS PER DWG START TIME:
 _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
116 - (QC3- Inspect Part Finish)
130 - (Identify as per dwg & Stock Location: ST 114)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	.6820 ft (.341 ea)	100-Doosan - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M6061T6R1.500	1	40	0

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches $\pm$ 0.030	0.910 0.850		
2	Basket Strut Clevis	0.438Inches $\pm$ 0.010	0.448 0.428		
3	Basket Strut Clevis	0.380Inches $\pm$ 0.030	0.410 0.350		
4	Basket Strut Clevis	0.625Inches $\pm$ 0.010	0.635 0.615		
5	Basket Strut Clevis	1.750Inches $\pm$ 0.030	1.780 1.720		
6	Basket Strut Clevis	3.500Inches $\pm$ 0.030	3.530 3.470		
7	Basket Strut Clevis	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	
8	Basket Strut Clevis	0.030Inches $\pm$ 0.030	0.060 0.000		
9	Basket Strut Clevis	0.060Inches $\pm$ 0.030	0.090 0.030	Radius	
10	Basket Strut Clevis	0.196Inches $\pm$ 0.006 - 0.001	0.202 0.195	Diameter	
11	Basket Strut Clevis	0.261Inches $\pm$ 0.006 - 0.001	0.267 0.260	Diameter	
12	Basket Strut Clevis	0.410Inches $\pm$ 0.030	0.440 0.380	Radius	
13	Basket Strut Clevis	1.130Inches $\pm$ 0.030	1.160 1.100		
14	Basket Strut Clevis	0.188Inches $\pm$ 0.010	0.198 0.178		
15	Basket Strut Clevis	0.190Inches $\pm$ 0.030	0.220 0.160		
16	Basket Strut Clevis	0.500Inches $\pm$ 0.030	0.530 0.470		
17	Basket Strut Clevis	0.750Inches $\pm$ 0.010	0.760 0.740		
18	Basket Strut Clevis	0.403Inches $\pm$ 0.000 - 0.005	0.403 0.398	Diameter	
19	Basket Strut Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	
20	Basket Strut Clevis	0.750Inches $\pm$ 0.010 - 0.000	0.760 0.750		
21	Basket Strut Clevis	0.160Inches $\pm$ 0.030	0.190 0.130		
22	Basket Strut Clevis	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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CANADA
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Container No: S174461



Part: D4776-1

Job No: 193742

Serial No/Batch: S174461

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/23/19